

Date: Friday, 23/05/2008 12:41:39 PM
 User: Julie Lecocq

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : LABEL PLATE |
| Job Number : 39457 | |
| Estimate Number : 10599 | |
| P.O. Number : | Part Number : D2506 |
| This Issue : 23/05/2008 S.O. No. : | Drawing Number : D2506 REV E |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : E |
| Previous Run : 37446 | Material : |
| Written By : | Due Date : 06/06/2008 Qty: 25 Um: Each |
| Checked & Approved By : <u>JUD 08.5.23</u> | |
| Comment : Est. B 01.06.08 Now laser cut EC est C 06.12.13 ecn 822 ec | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S20GA | 304/316 .040 Sheet |
|-----|-----------|--------------------|



39.



Comment: Qty.: 1.2810 sf(s)/Unit Total : 32.0250 sf(s)

304/316 .040 Sheet

Batch: 108156 B 8-5-28

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|

**Comment:** FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: EProg Rev: E

IB 8-5-28

(30)

2-Deburr if necessary

IB 8-5-28

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



IB 8-5-28

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

500/05/27 (30) 100000

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

Done at step # 22
 500/05/27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 12:41:39 PM
User: Julie Lecoq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 39457

Part Number: D2506

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

SB 08/06/03 (30)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
08/06/05 (x30)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAT Duval

SS 08/06/05 (x30)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/05
MF 08-06-05

Job Completion



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|--|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 3945 F |
| Description: Label Plate | | Part Number: D2506 |
| Inspection Dwg: D2506 Rev: E | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 32.63 | +/-0.030 | 32.25 * | | | | |
| 39.00 | +/-0.030 | 39.00 * | | | | |
| 4.50 | +/-0.030 | 4.50 * | | | | |
| 1.31 | +/-0.030 | 1.311 * | | | | |
| 1.88 | +/-0.030 | 1.878 * | | | | |
| 0.040 | +/-0.010 | 0.037 * | | | | |
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| Measured by: IB | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 8-5-28 | Date: 08/05/29 | Date: | N/A |

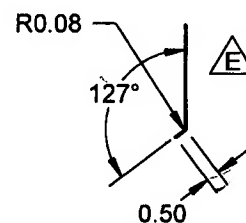
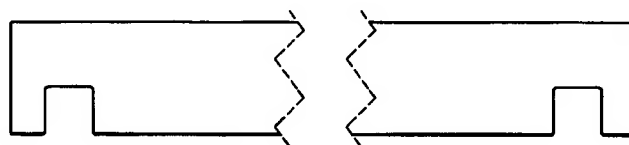
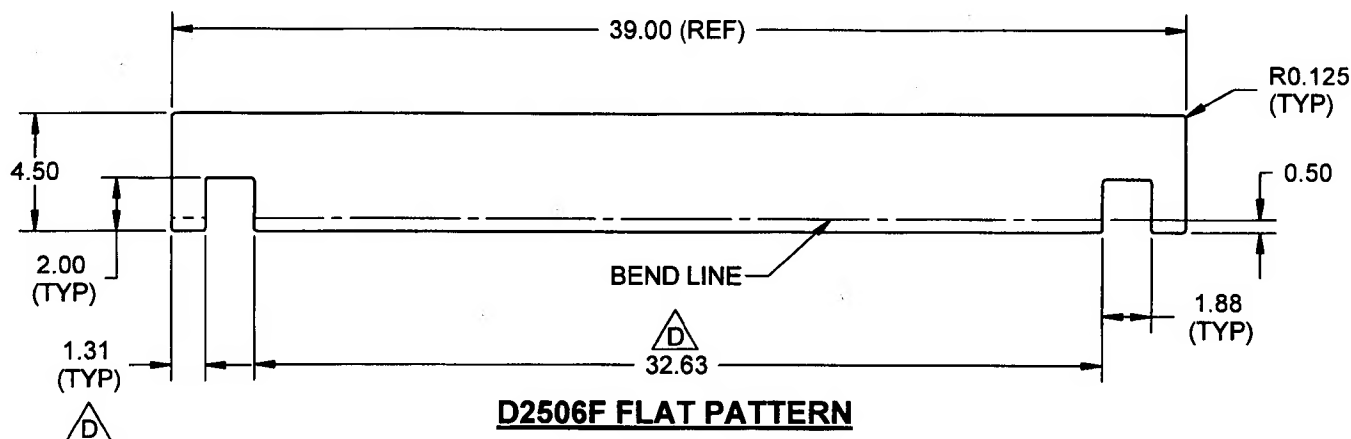
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------|------------|-------------|
| A | 06.08.29 | New Issue | KJ/JLM | |
| B | 06.12.20 | Dwg Rev. updated | KJ/JLM | |
| C | 07.09.06 | 0.040 dimension added | KJ/JLM | [Signature] |

DART

RELEASED

06.11.28

| DESIGN BW | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|------------------|----------------------|---|------------------------|
| CHECKED LE | APPROVED H | DRAWING NO. D2506 | REV. E SHEET 1 OF 1 |
| DATE 06.11.20 | TITLE LABEL PLATE | | SCALE 1:7 |
| REV | DATE | DESCRIPTION | |
| A | 95.11.26 | NEW ISSUE | |
| B | 96.06.18 | RE-DESIGN OF LABEL PLATE | |
| C | 96.09.04 | RE-DESIGN OF LABEL PLATE | |
| D | 99.10.04 | 32.63 WAS 32.25; 1.31 WAS 1.50 | |
| E | 06.11.20 | REMOVE 10° BEND; ADD NOTES; 127° WAS 126° | |

**D2506 LABEL PLATE****NOTES:**

- 1) MATERIAL: STAINLESS STEEL AISI 304/316 SHEET 0.040 THICK PER MIL-S-5019 (REF DART SPEC M304S20GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 39457

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